

Work Order ID 73858

Friday, September 16, 2011 1:26:10 PM



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Item ID: D2649

Accept



Setup Start



Revision ID:

Stop



Item Name: Cross Bolt Spacer

Start Date: 9/16/2011 Start Qty: 600.00



Cust Item ID:

Required Date: 10/21/2011 Req'd Qty: 600.00



Customer:

Reference:

[Handwritten signature]

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2649

Rev B1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

mf 11/09/21

301

Hardinge CNC Lathe Small

Machine as per folio FA214 on cobra machine.

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

mf 11/09/21

301

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

29 11-11-2

301

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 Skidtubes		0.00							
Skidtubes	Memo 1- clean crossbolt spacer with ultra brighth aluminum cleaner before storing.	0.00							
	<i>Ac 11.11.07</i>								
130 Packaging	Identify as per dwg & Stock Location: <i>L4</i>	0.00							
Packaging	Memo ***STOCK IN SKIDTUBE CELL***	0.00							
	<i>11/11/09</i>								
140 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							
	<i>11-11-09</i>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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T

Work Order ID: 73858



Parent Item: D2649

Parent Item Name: Cross Bolt Spacer

Start Date: 9/16/2011

Required Date: 10/21/2011

Start Qty: 600.00

Required Qty: 600.00

Comments: IPP F02.03.26 Added turning on Cobra NG
added cleaning DD verified :EC

IPP Rev:G 10.05.11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6T0.375W.058

Purchased

No

100

f

0.5780

0.2833

178.9263



PR 11-2

6061-T6 RD Tube .375 x.058W

Location

Loc Qty

Loc Code

MAT014

0.578

~~116~~ 116920

0.578

M 18956

fo. 266
72.0 remaining

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

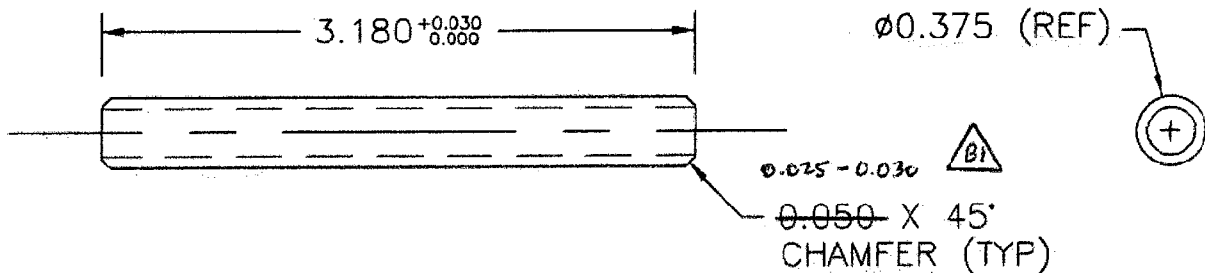
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries



DESIGN <i>DMS</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMS</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	# CP 02.06.13	REDUCE CHAMFER PER TSR 1246.	

RELEASED
98.01.20 DS



MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED